

Work Order ID **55960**

February 8, 2010 11:40:54 AM



Page 1

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 2/08/10

Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plant

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4055

~~PAI~~ ~~PAS~~ ~~PAI~~ ~~PAS~~

rev A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 11330  
Purchase part as per Dwg D4055  
Possible Supplier: GFI  
Material release note required

10-2-08  
(3)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

110/3/4 (3)

120

QC6- Inspect dimensions to drawing

0.00



QC

810/3/4 to polem Dwg only  
Memo

0.00

Quality Control

change on Dwg. ~~PAI~~ parts not in match  
no inspection to ~~reference~~ Dwg.

QC APPROVAL

PRELIMINARY ISSUE

~~PAI~~ ~~PAS~~ ~~PAI~~ ~~PAS~~  
5

Ph - 7

# Dart Aerospace Ltd

W/O: 55960

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<del>Change A on Transition 2090 to 2095</del>					

Part No: D4055-7 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 4 Date: 10/06/28  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 55960

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<del>10/03/08</del>	<del>100</del>	<del>Found @ inspection that the .50" diameter hole was .56-.57 @ G.P.Z. N/A</del>						<del>10/03/08</del>
		Changes From Pat to Rev A Dwg. mark part non conforming		Red tag parts.	N/A	Rev A is good to parts. minor changes & needed. this parts me to Rev A.		8 10/04/22

NOTE: Date & initial all entries

**Work Order ID 55960**

February 8, 2010 11:40:55 AM



Page 2

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

*N/A J-10.04.13.*

150

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

Packaging

*Prel Shelf*

0.00

*J-10.03.13**(3)**WA lat Lovers**(2)**10.06.28*

# Work Order ID 55960

February 8, 2010 11:40:55 AM



Page 3

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Test*

*10/06/28*

*BS 10-4-14*

*3*

POSITIVE RECALL

EFFECTIVE *10/2/08* AUTH *U*

RELEASED *[Signature]* DATE *10/06/28* *Q42*

# Picklist Print

February 8, 2010 11:40:54 AM

Page 1

Work Order ID: 55960



Parent Item: D4055-7



Parent Item Name: Tank Fwd End

Start Date: 2/08/10

Required Date: 2/22/10

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-7P		Purchased	No			110	Each	0.0000	3.0000			



Tank Fwd End



*2/10/3/4 (3)*



180 AVENUE LABROSSE  
POINT-CLAIRE, QC, CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		PAGE
JR - DY	MO. - MO.	AN. - YR			
02	03	10	0433554		1/1




VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299	0210446	PO11330	

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
3	D4055-7P	TANK FWD END
		CERTIFICATE OF CONFORMANCE REQ
	MFG. JOB# J0210446-001 QTY 3	
	(1) Box	
		

EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>1</u>		OUR JOB NO <u>J0210446</u>		SHIPPING MEMO <u>0433554</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>--</u>	<u>3 PCS</u>	<u>PO11330</u>	<u>D4055-7P</u>		<u>TANK FWD END</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>AL 6061-T6</u>		<u>SAMUEL / ALCOA INC</u>		<u>608951</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0210446-001 (3 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 MARCH 2010

G.F.I. Q.C..REP.





LES METAUX SPECIALISES SAMUEL  
21525 CLARK-GRAHAM  
BAIE D'URFE, QUEBEC, CANADA  
H9X 3T5

(514) 457-3399 FAX (514) 457-9393

No 001591859



TRANSPORTEUR/CARRIER NAME  
ASTERO TRANSPORT

CAMION/TRUCK  
099

NOM DE LA BRANCHE/SALES BRANCH NAME  
SAMUEL & FILS & CIE (QUEBEC) L

DATED/EXP/DATE OF SHIPMENT  
2/16/10

PAGE 1 DE/OF 1

**VENDU À/SOLD TO:**

GFI, DIVISION DE THOMAS & BETTS LTEE  
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

(514) 630-4877

**EXPÉDIÉ À/SHIP TO: TÂB: PPD**

GFI INC.

180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

CA

(201009-00001)

N° COMMANDE  
N° ITEM  
000752-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 76423  
4 PCS AL. SH. 6061 T6  
.0630"x48"x144"  
QQA 250/11

Cert/Test: FAX  
174 LVR

#Pièce AS06348144QM

Description

Art

Pd ca

Qté

#Étiq

Vendeur Org

#Étiq mln

#À soul

4

192.000

174

Étq princ

#Coul

764479

4947487

ALR

US

Total:

4

192.000

174

D654824 608951

Poids total:

#Total paquets:

1

174 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ

LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ

CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX

SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS

RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

MÉLISSA DIAMOND  
ADMINISTRATION

DATE 16/02/10



NIR: R-539477-1

PREL PAR	<input checked="" type="checkbox"/> PORTPAYÉ/REPAID	<input type="checkbox"/> PORTDU COLLECT	INST. VOITURIER/DRIVER INSTRUCTIONS	VAL. (92.0005 max moins d'avis contraire) VAL. (92.0005 max 5.2 (0.10) moins d'avis contraire) VAL. DÉCLARÉE DE L'EXPÉDITEUR DECLARED VALUE OF SHIPMENT
EXPÉDITEUR/DISPATCHER			VOITURIER/DRIVER	REÇU PAR/RECEIVED BY

1. ORIGINAL - NON NÉGOCIABLE (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)



# CERTIFIED INSPECTION REPORT

**Alcoa Inc.**

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per: *[Signature]*  
Malcolm Murphy  
Director of Manufacturing Davenport Works

*[Signature]*  
Kenton P. Young  
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS  
Ship From: RIVERDALE, IA.

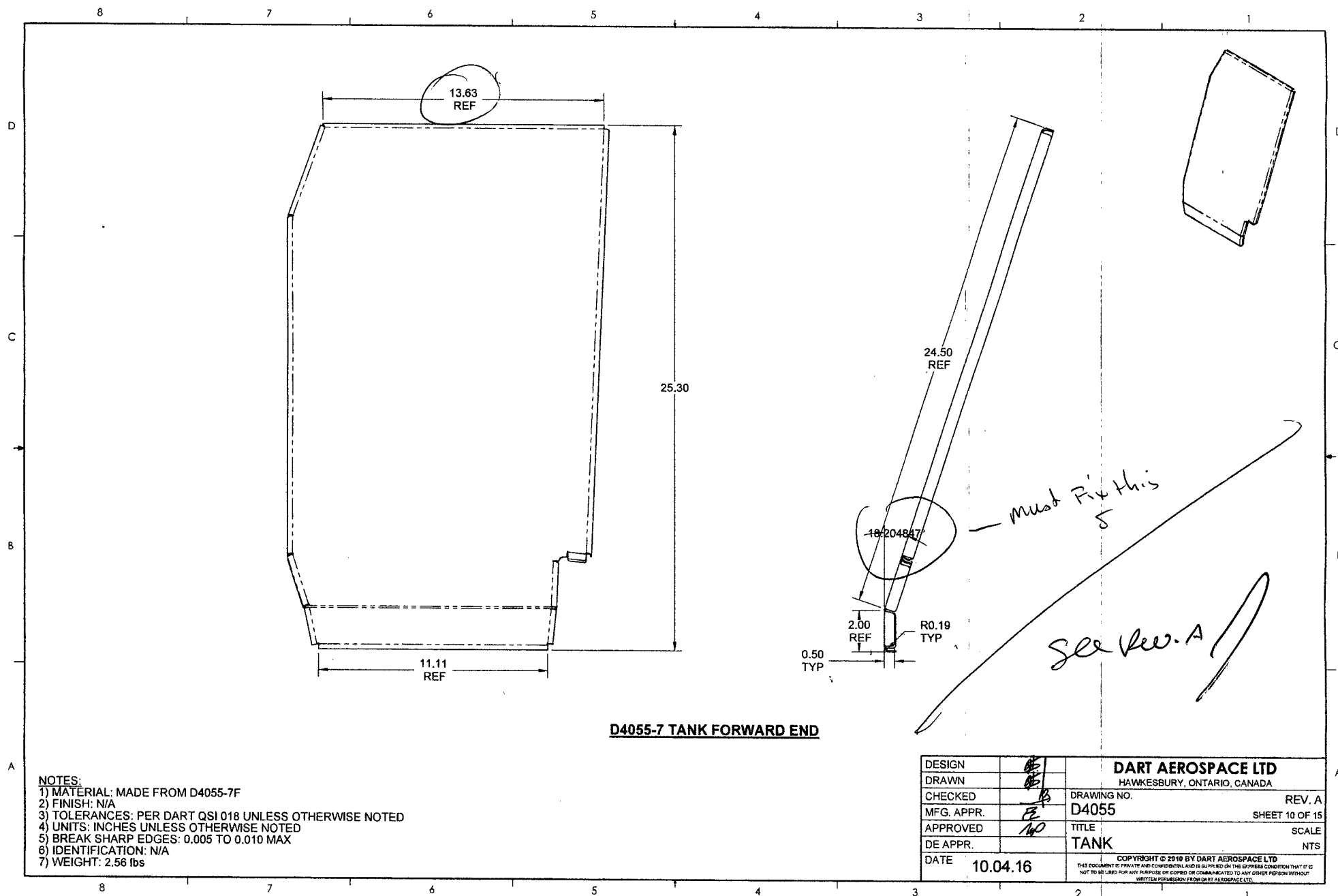
1058276 0  
Ship Date B.L. No. Invoice No. Alcoa No. Item Page 2  
2009-10-15 4303234 00000 1000143904-6 DCE-43904-6  
P.O. No./Govt Contract No. Customer Alcoa Item  
N22238 Ln#: 6 SAMUEL SON & CO LT 0041110647R02

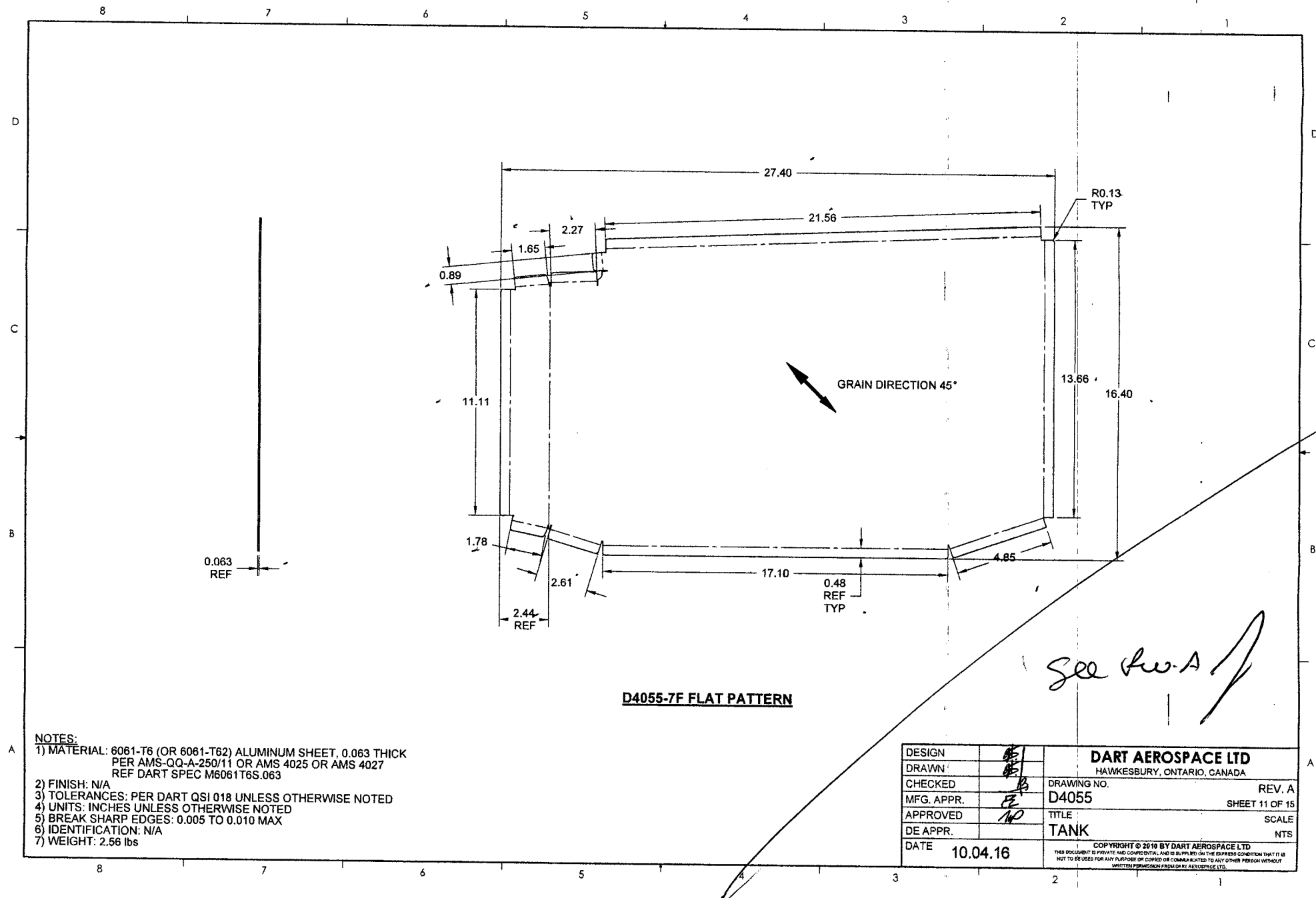
CQR: 0222751.2 -Specification Limits (cont.)  
Lot: 608951

- Mechanical, Physical, Metallography, Quantometer Results -  
Tmpr Dir No-> UTS TYS EL4D  
T6 Long Transv. Test KSI KSI PCT  
2 50 44.8 10.9  
49.9 44.8 10.9

Cast Number Chemical - OES SI FE CU MN MG CR ZN TI  
H8054013 Actuals 0.66 0.5 0.26 0.06 0.9 0.19 0.05 0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

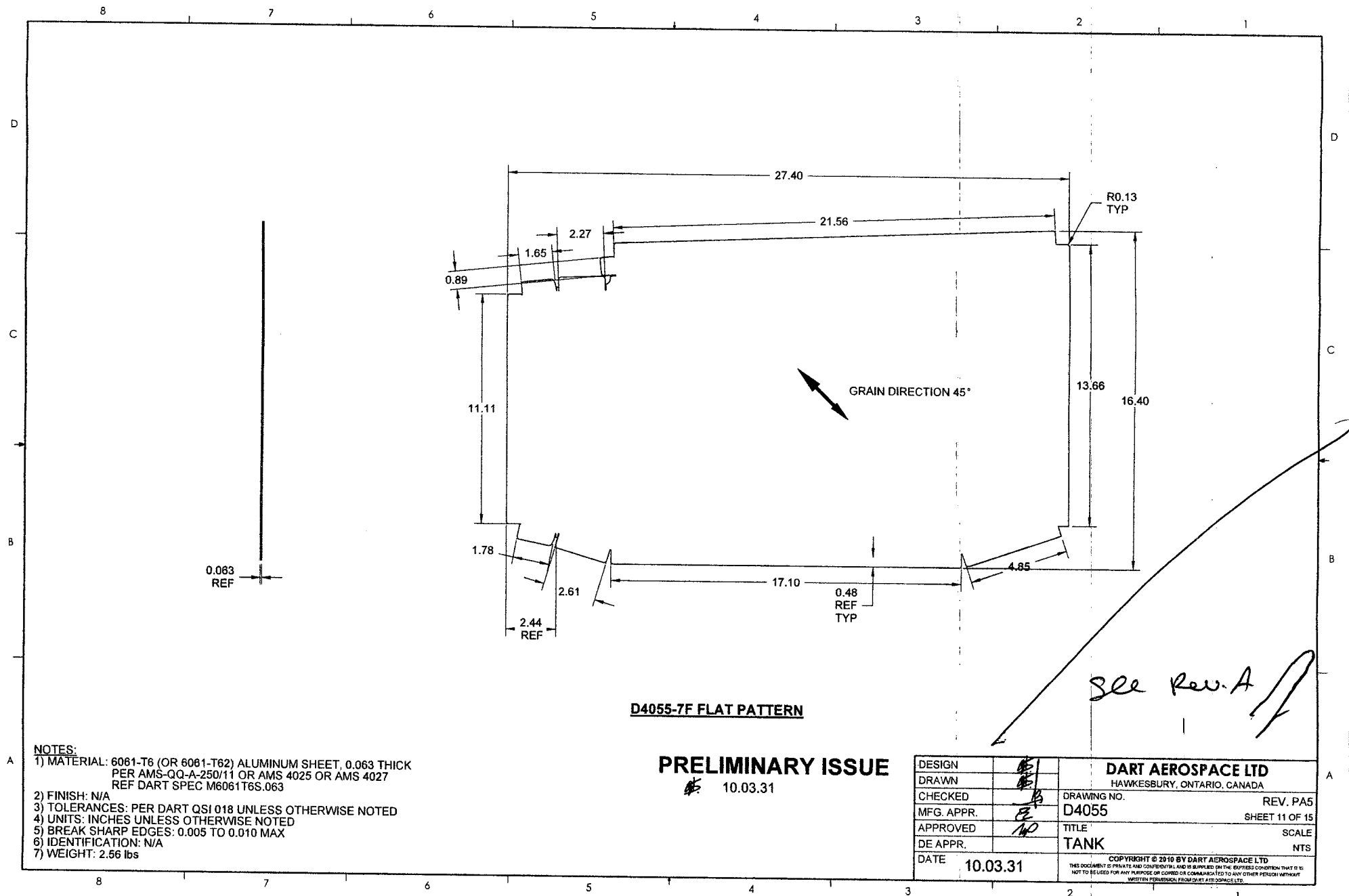


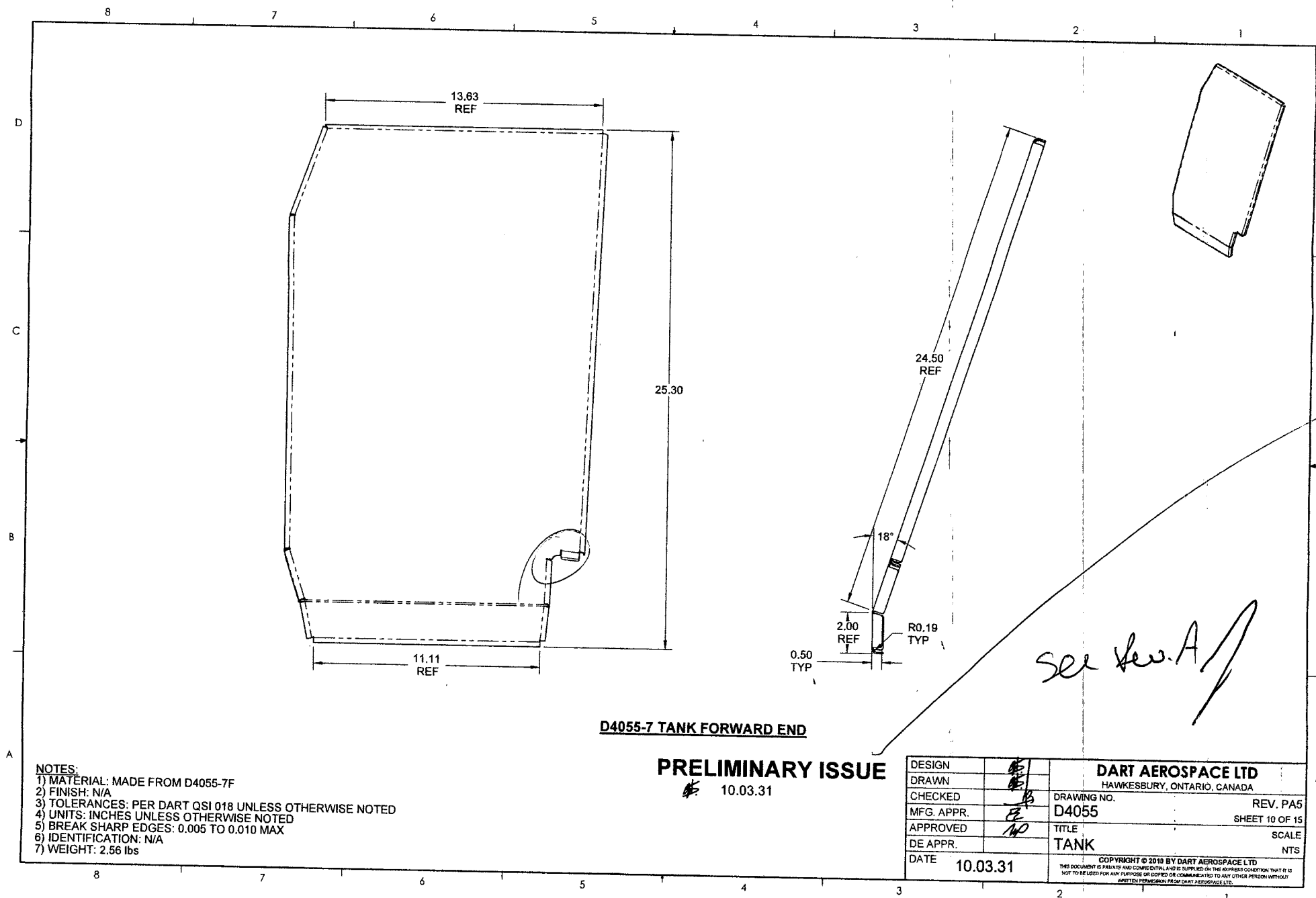


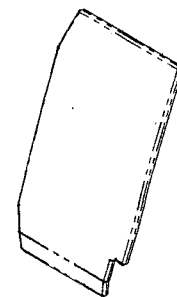
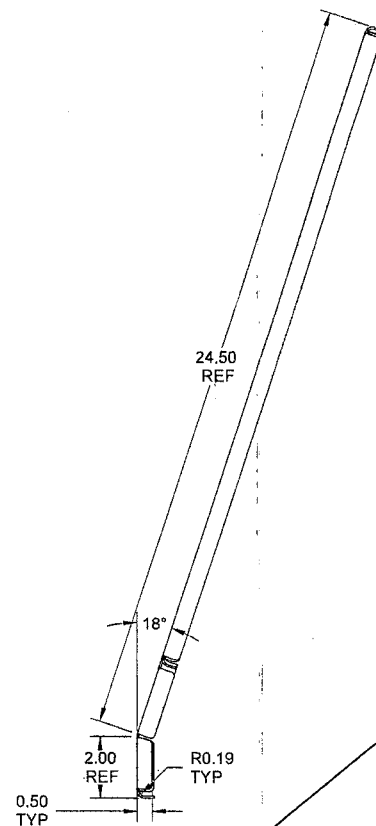
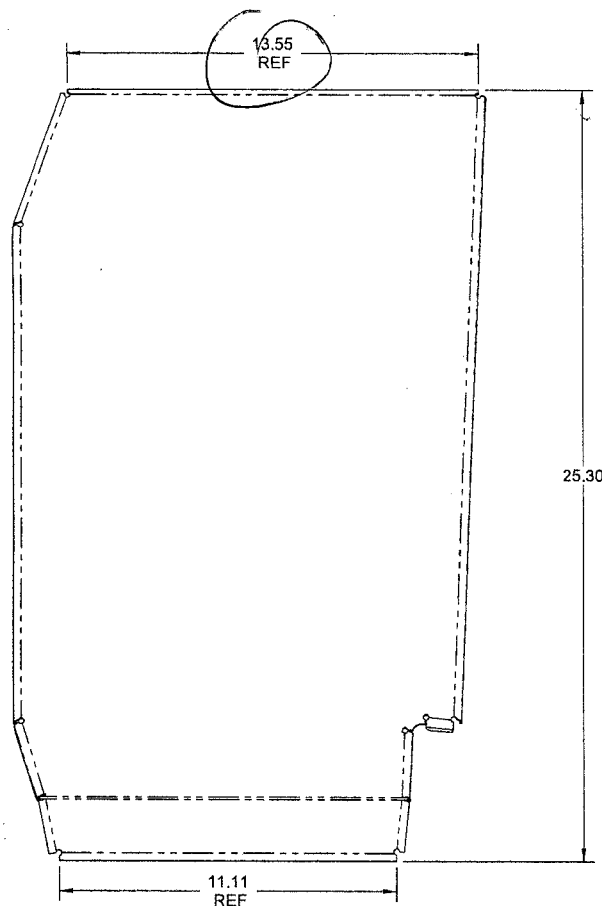
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4055</b>	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	<b>10.04.16</b>	<small>COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	







*See Rev. A*

# **D4055-7 TANK FORWARD END**

**PRELIMINARY ISSUE**

10.01.11

## **NOTES:**

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.01.11

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

**D4055**

TITLE

**TANK**

REV. PA1

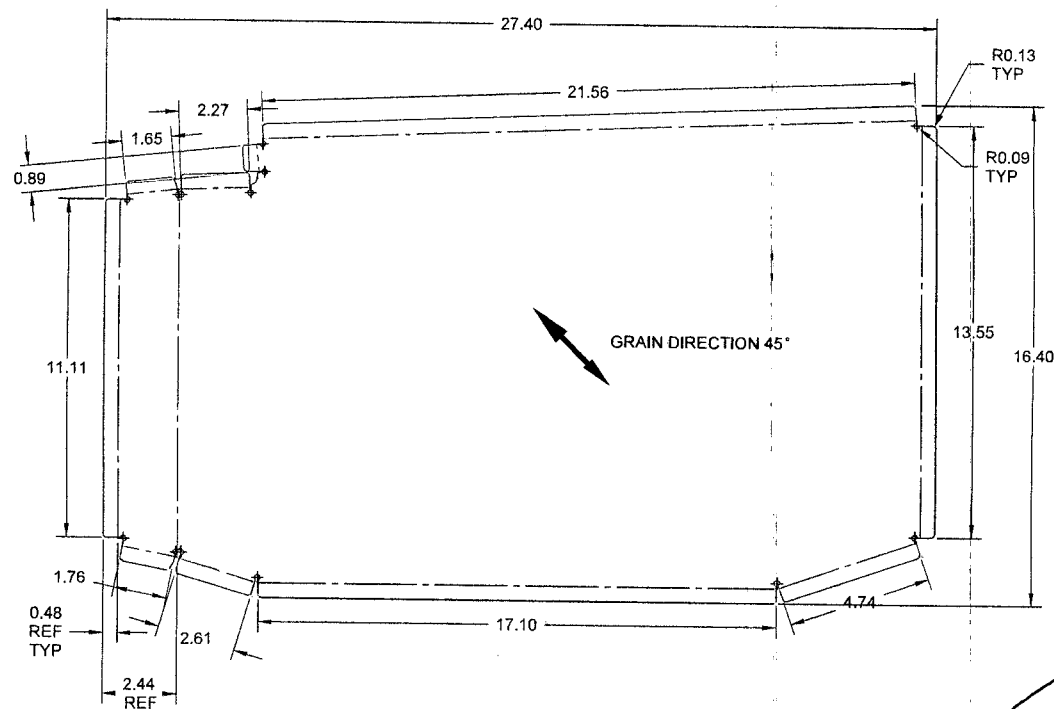
SHEET 10 OF 15

SCALE

NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

0.063  
REF



# **D4055-7F FLAT PATTERN**

**PRELIMINARY ISSUE**

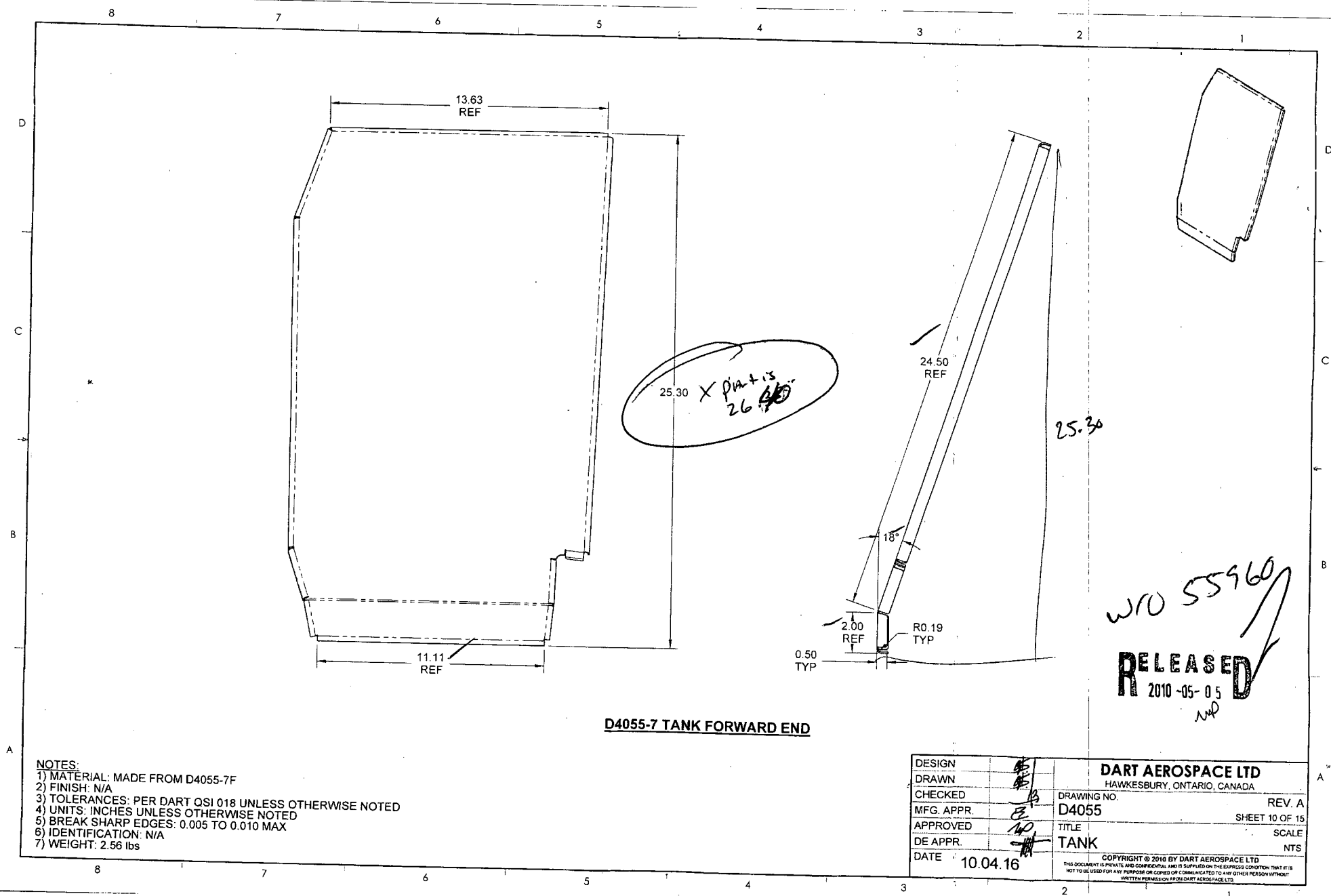
10.01.11

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4055</b>	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	<b>10.01.11</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMPILED INTO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

*See Rev. A*



WFO 55960

**RELEASED**  
 2010-05-05  
 NP



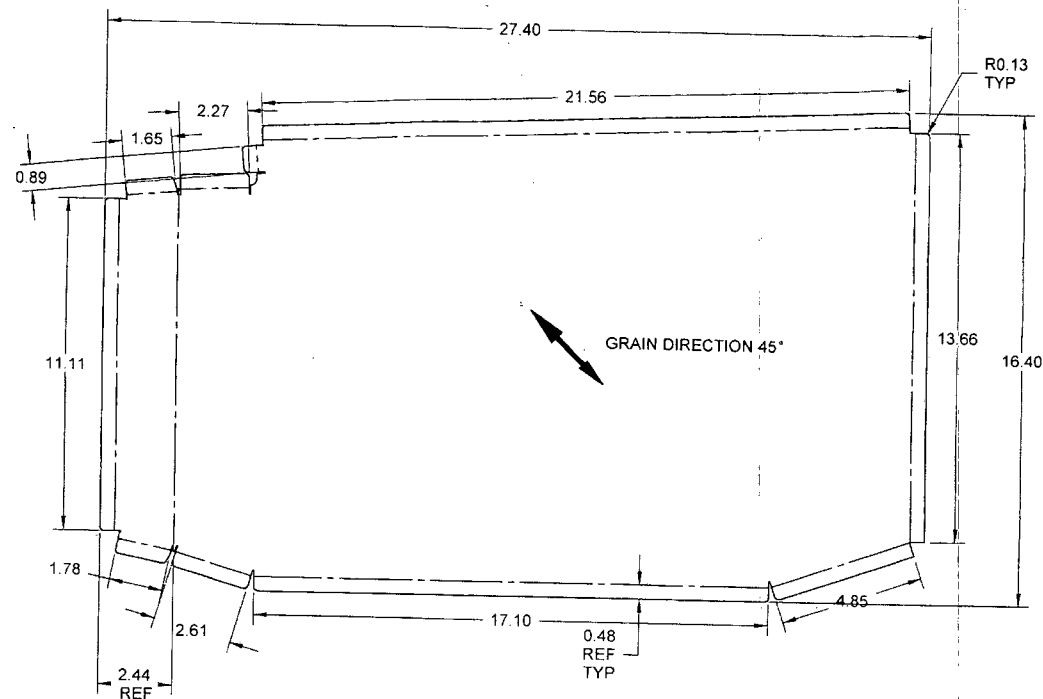
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









**D4055-7F FLAT PATTERN**

**RELEASED**  
2010-05-05  
ND

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4055</b>	SHEET 11 OF 1
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	<b>10.04.16</b>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries